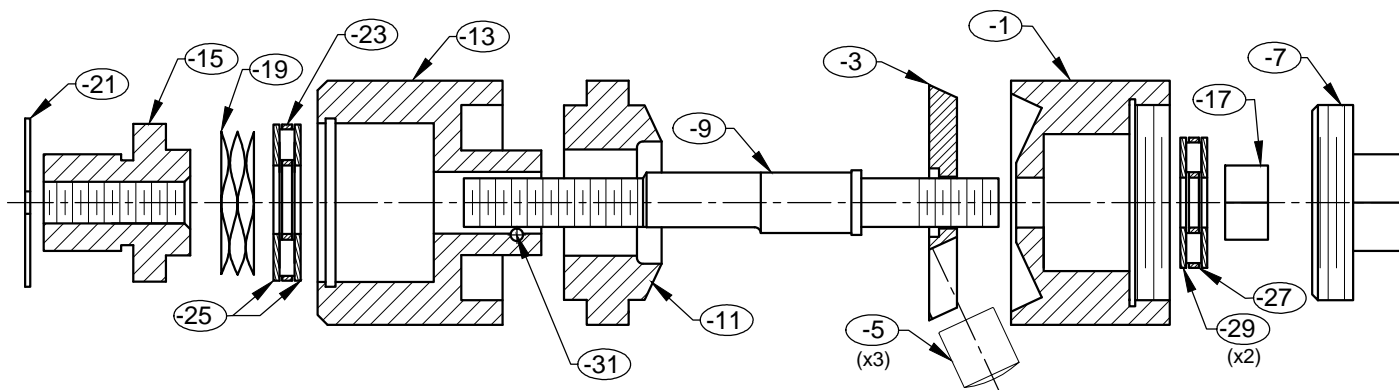


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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CH'D -1, -3, -9 -11 & -13 DATUM TARGET DESIGNATIONS AND FEATURE CONTROL FRAMES. ADDED 2ND FLAT ON -13.	7/26/12	RJC	SE



#### NOTES

- 5 ROLLERS AND -3 RETAINER MUST TURN SMOOTHLY ON -1 BASE WHEN ASSEMBLED.
- FLAT END OF -5 ROLLERS MUST FACE THE CENTER OF TOOL WHEN ASSEMBLED.

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	BASE		SEE CHART	2
			-3	1	RETAINER		SEE CHART	3
			-5	3	ROLLER		SEE CHART	4
			-7	1	CAP		SEE CHART	5
			-9	1	STUD		SEE CHART	6
			-11	1	DUAL SEAT		SEE CHART	7
			-13	1	RECEIVER		SEE CHART	8
			-15	1	TENSIONER		SEE CHART	9
		B/O	-17	1	DISTORTED THREAD LOCK NUT	STEEL	1/4-20 UNC x 7/32 Ht. MCMaster-CARR #95065A150	1
		B/O	-19	1	CREST TO CREST FLAT WIRE WAVE SPRING	STEEL	.750 OD., .550 ID., WIRE THICK. .013, THREE TURNS SMALLEY RING CO. #CS075-H1	1
		B/O	-21	1	INTERNAL SNAP RING	STEEL	Ø7/8 BORE MCMaster-CARR #99142A410	1
		B/O	-23	1	THRUST BEARING (SPRING SIDE)	STEEL	Ø3/8 ID. x 13/16 OD. x 5/64 WIDTH APPLIED (TIMKEN #NTA-613)	1
		B/O	-25	2	BEARING WASHER	STEEL	Ø3/8 ID. x 13/16 OD. x 1/32 WIDTH APPLIED (TIMKEN #TRA-613)	1
		B/O	-27	1	THRUST BEARING	STEEL	Ø1/4 ID. x 11/16 OD. x 5/64 WIDTH APPLIED (TIMKEN #NTA-411)	1
		B/O	-29	2	BEARING WASHER	STEEL	Ø1/4 ID. x 11/16 OD. x 1/32 WIDTH APPLIED (TIMKEN #TRA-411)	1
		B/O	-31	1	ROLL PIN	STEEL	Ø3/32 x 3/8	N/S
ASSY #								

#### BEARINGS & TOOLS COVERED

BEARING #	TOOL #
206-010-470-101	RBST2812-P

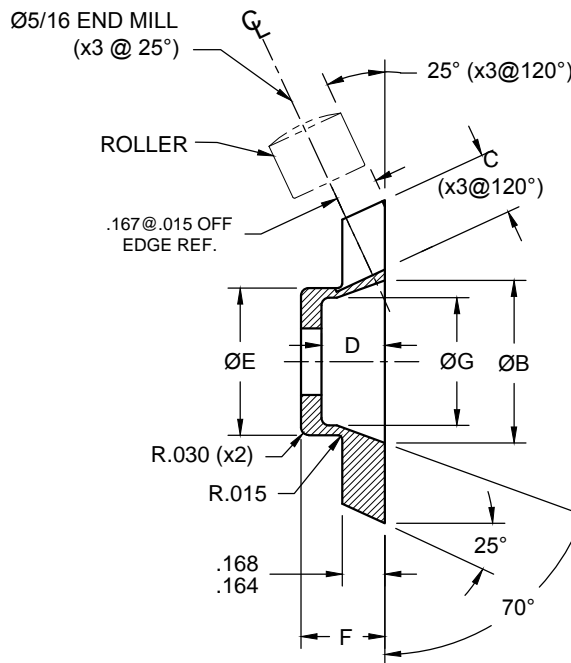
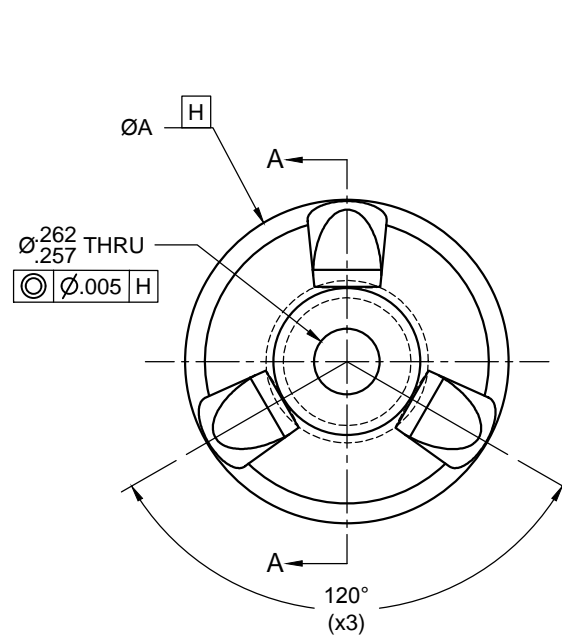
**RED BARN MACHINE**

TITLE RBST2800-P SERIES FOR BELL BEARINGS  
PORTABLE TRI-ROLLER SWAGING TOOLS

DWG NO.	SEE CHART ABOVE FOR TOOL No.	REV	1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1		DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING SEE CHART	
SCALE	NTS	DATE	11-9-09
		SHEET	1 of 9



REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	CH'D -3 DATUM TARGET DESIGNATIONS AND FEATURE CONTROL FRAMES.	7/26/12	RJC



③  
RETAINER

SECTION A-A

# NOTES

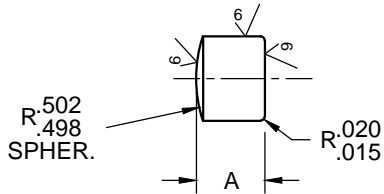
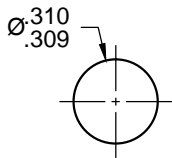
- BREAK ALL SHARP CORNERS (.015/.03).

TOOL #	ØA +02 -002	ØB +005 -005	C +003 -003	D +010 -010	ØE +005 -005	F +005 -005	ØG +005 -005	P.D. REF.	MATERIAL
RBST2812	1.265	.635	.247	.250	.575	.328	.500	.837	BRONZE RND. BAR Ø1-3/8 x 1/2

<b>RED BARN MACHINE</b>	
TITLE RBST2800P SERIES FOR BELL BEARINGS PORTABLE TRI-ROLLER SWAGING TOOL	
DWG NO. TOOL#(see chart)-3 RETAINER	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON BEARING SEE CHART
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 11-9-09 SHEET 3 of 9


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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED

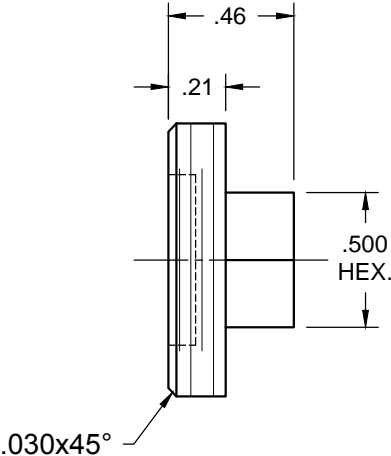
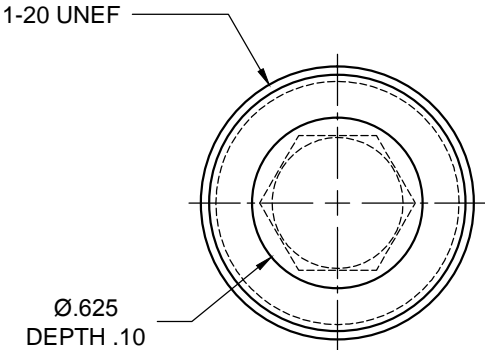


⑤  
ROLLER

TOOL #	A +.001 -.001	MATERIAL
RBST2812	.251	.310 MINUS GAUGE PIN MSC #89031009


 RED BARN MACHINE		
TITLE RBST2800-P SERIES FOR BELL BEARINGS PORTABLE TRI-ROLLER SWAGING TOOL		
DWG NO.	TOOL#(see chart)-5 ROLLER	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1		DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT: RC 55-60 FINISH: SPEC:
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING SEE CHART
SCALE NTS	DATE 11-9-09	SHEET 4 of 9

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED

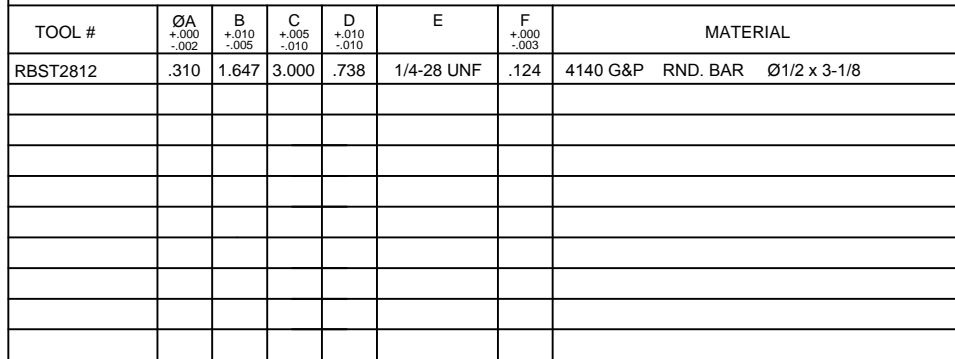



⑦  
CAP

TOOL #		MATERIAL
RBST2812		1018 RND. BAR Ø1 x 5/8

 <b>RED BARN MACHINE</b>	
<b>TITLE</b> RBST2800-P SERIES FOR BELL BEARINGS PORTABLE TRI-ROLLER SWAGING TOOL	
<b>DWG NO.</b> TOOL#(see chart)-7 CAP	<b>REV</b> 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1	<b>DRAWN BY:</b> PERRITT <b>APPROVED</b> <i>D Weil</i> <b>HEAT TREAT</b> <b>FINISH</b> BLACK OXIDE <b>SPEC</b>
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON BEARING SEE CHART
<b>SCALE</b> NTS	<b>DATE</b> 11-9-09 <b>SHEET</b> 5 of 9

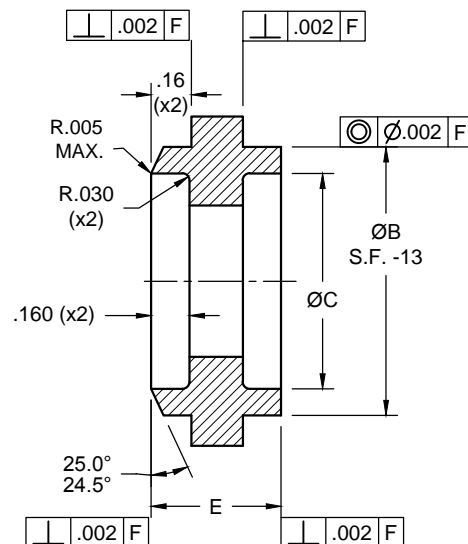
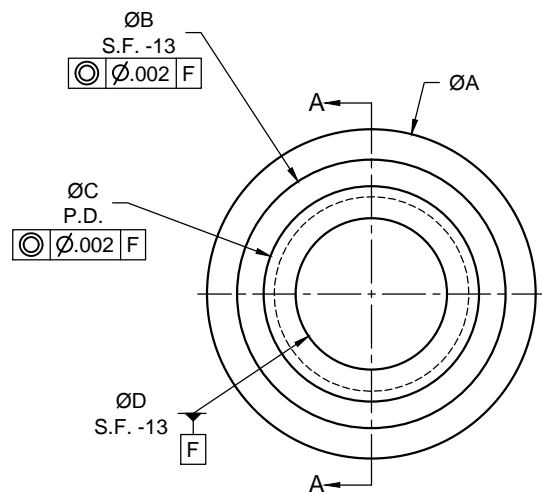
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CH'D -9 DATUM TARGET DESIGNATIONS AND FEATURE CONTROL FRAMES.	7/26/12	RJC	SE



 <b>RED BARN MACHINE</b>			
<b>TITLE</b> RBST2800-1 SERIES FOR BELL BEARINGS PORTABLE TRI-ROLLER SWAGING TOOL			
<b>DWG NO.</b> TOOL#(see chart)-9 STUD			<b>REV</b> 1
<b>UNLESS OTHERWISE SPECIFIED</b> DIMENSIONS ARE IN INCHES  <b>TOLERANCES ON:</b> DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		<b>DRAWN BY:</b> PERRITT <b>APPROVED</b> <i>D Weid</i> <b>HEAT TREAT</b> <b>FINISH</b> BLACK OXIDE <b>SPEC</b>	
<b>UNLESS OTHERWISE SPECIFIED</b> 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		<b>USED ON BEARING</b> <b>SEE CHART</b>	
<b>SCALE</b> NTS	<b>DATE</b> 11-9-09	<b>SHEET</b> 6	<b>of 9</b>

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CH'D -11 DATUM TARGET DESIGNATIONS AND FEATURE CONTROL FRAMES.	7/26/12	RJC	SE



SECTION A-A

-11

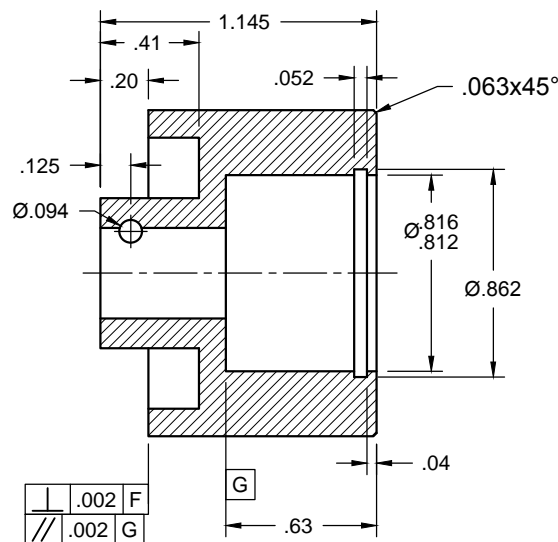
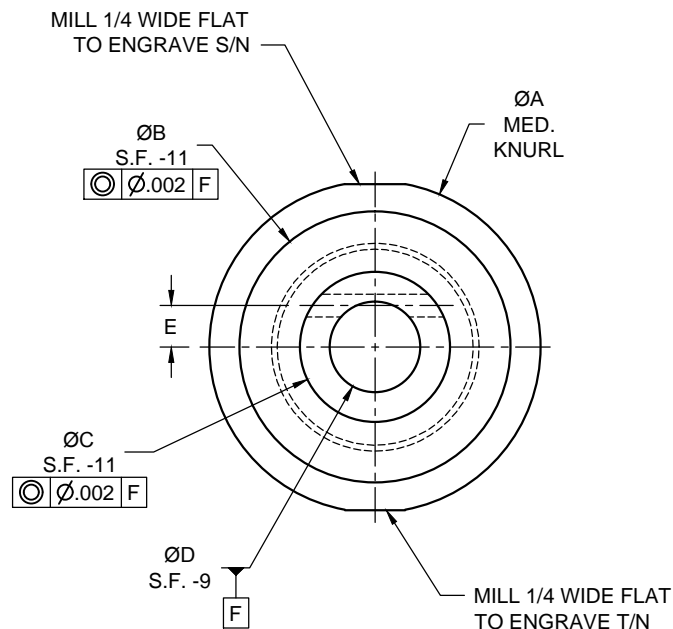
DUAL SEAT

TOOL #	ØA +.010 -.020	ØB +.000 -.003	ØC +.002 -.000	ØD +.005 -.003	E +.010 -.010	MATERIAL
RBST3008P	1.375	1.122	.837	.632	.710	4140 Q&T RND. BAR Ø1-3/8 x 7/8

<b>RED BARN MACHINE</b>	
TITLE RBST2800-P SERIES FOR BELL BEARINGS PORTABLE TRI-ROLLER SWAGING TOOL	
DWG NO. TOOL#(see chart)-11 DUAL SEAT	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH BLACK OXIDE SPEC USED ON BEARING SEE CHART
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 11-9-09 SHEET 7 of 9

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	CH'D -13 DATUM TARGET DESIGNATIONS AND FEATURE CONTROL FRAMES. ADDED 2ND FLAT.	7/26/12	RJC



-13

RECIEVER

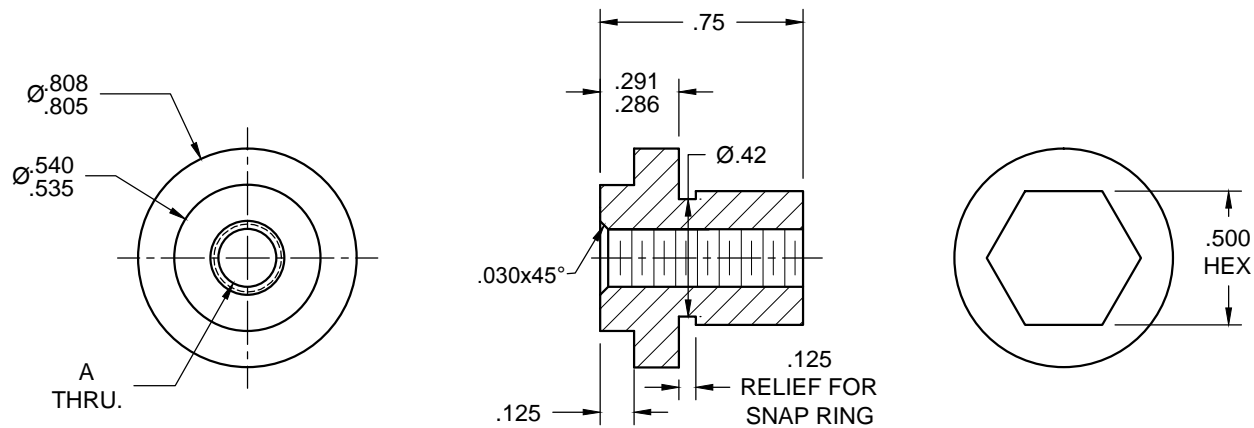
TOOL #	ØA +.010 -.010	ØB +.003 -.000	ØC +.003 -.003	ØD +.002 -.000	E +.003 -.000	MATERIAL
RBST2812	1.375	1.125	.622	.312	.175	4140 Q&T RND.BAR Ø1-3/8 x 1-1/4

<b>RED BARN MACHINE</b>	
TITLE RBST2800-P SERIES FOR BELL BEARINGS PORTABLE TRI-ROLLER SWAGING TOOL	
DWG NO. TOOL#(see chart)-13 RECIEVER	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH: BLACK OXIDE SPEC: USED ON BEARING SEE CHART
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE NTS DATE 11-9-09 SHEET 8 of 9




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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



(-15)  
TENSIONER

TOOL #	A	MATERIAL
RBST2812	1/4-28 UNF	4140 Q&R RND. BAR Ø7/8 x 7/8

 <b>RED BARN MACHINE</b>			
<b>TITLE</b> RBST2800-P SERIES FOR BELL BEARINGS PORTABLE TRI-ROLLER SWAGING TOOL			
<b>DWG NO.</b> TOOL#(see chart)-15 TENSIONER			<b>REV</b> 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1		FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		<b>DRAWN BY:</b> PERRITT <b>APPROVED</b> <i>D Weil</i> <b>HEAT TREAT FINISH</b> BLACK OXIDE <b>SPEC</b> USED ON BEARING SEE CHART	
<b>SCALE</b> NTS	<b>DATE</b> 11-9-09	<b>SHEET</b> 9 of 9	

NOT APPROVED FOR PRODUCTION

 RED BARN MACHINE

NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

PART #	QTY	DESCRIPTION
-1	1	--

DRAWN BY: PERRITT	<div><div>RB</div>RED BARN MACHINE</div>		
CHECKED	TITLE		
HEAT TREAT FINISH SPEC	TITLE		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	FRACTIONS ± 1/32 ANGLES ±.5°		REV.
USED ON MODEL ?	DWG NO. PART #		
	SCALE NTS	DATE 1-28-06	SHEET 1 of 1
	UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		